

# Work Order ID 59202

Friday, May 28, 2010 9:17:50 AM



Page 1

Item ID: D2731-7

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 5/27/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2731	Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to .82"

Batch 45800

*Inf 10/06/05*

40

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D2731-7. □2-Check for crack while loading into the machine. □3-Tumble □4-Deburr any rough edges after tumbling

*M.A 10/06/07*

40

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*M.A 10/06/07*

40

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

Page 2

**Accept**

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

**Stop**

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

Plan  
Code

**Accept Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

QC8- Inspect parts - second check

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

\_\_\_\_\_

**HandFinish**

## Memo

0.00

## Hand Finishing

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\_\_\_\_\_

**Powdercoat**

## Memo

0.00

## Powder Coating

START TIME: 10:00am □ OVEN TEMPERATURE: 320°  
10:30am □ FINISH TIME: 3:00pm

W/O:		WORK ORDER CHANGES					
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**Work Order ID 59202**

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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 5/27/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				40	BR	10-6-8.	
170 	Identify as per dwg & Stock Location: <u>ST 470</u>	0.00							
Packaging Packaging	Memo	0.00				40	BR	10/06/08.	
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00						10/06/09	MF 10-6-9

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# Picklist Print

Friday, May 28, 2010 9:17:54 AM

Page 1

Work Order ID: 59202

Parent Item: D2731-7

Parent Item Name: Mounting Lug



Comments: IPP ☐ D ☐ 00.05.19 ☐ Added inspect level 8, removed P/O powder coating ☐ EC ☐

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P 		Purchased	No			100	Each	0.0000	1	40			
LUG D2423 		Manufactured	No			110	f	470.5321	0.0683	2.875789			
Lug Extrusion													

Location

MAT06

43722

→ 45800

Loc Qty

470.5320795

180

290.532079

Loc Code

2.875789 *mk 10/06/05*

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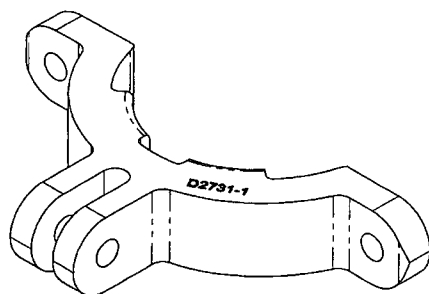
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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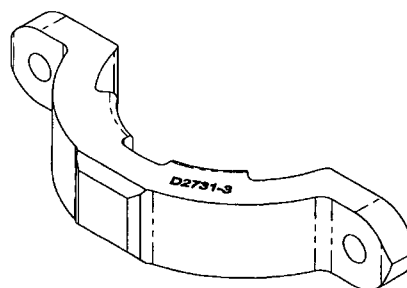
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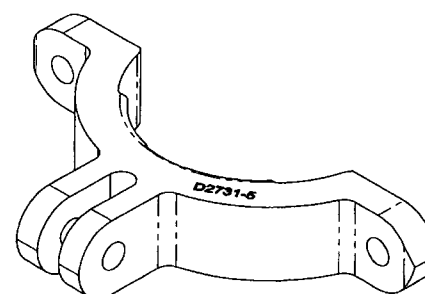
NOTE: Date & initial all entries



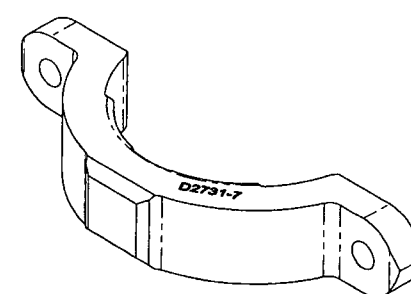
**D2731-1 MOUNTING LUG**



**D2731-3 MOUNTING LUG**



**D2731-5 MOUNTING LUG**



**D2731-7 MOUNTING LUG**

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005.
- 7) WEIGHT: -1: 0.17 lbs  
-3: 0.15 lbs  
-5: 0.16 lbs  
-7: 0.14 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 59202  
*BS 10-5-25*

**RELEASED**  
*CP/2/21/14*

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

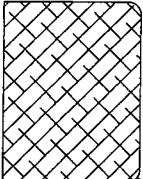
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

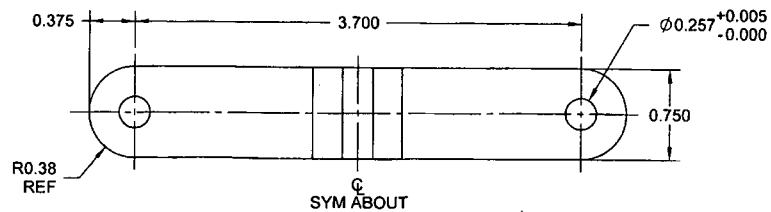
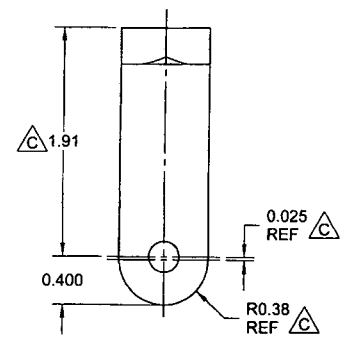
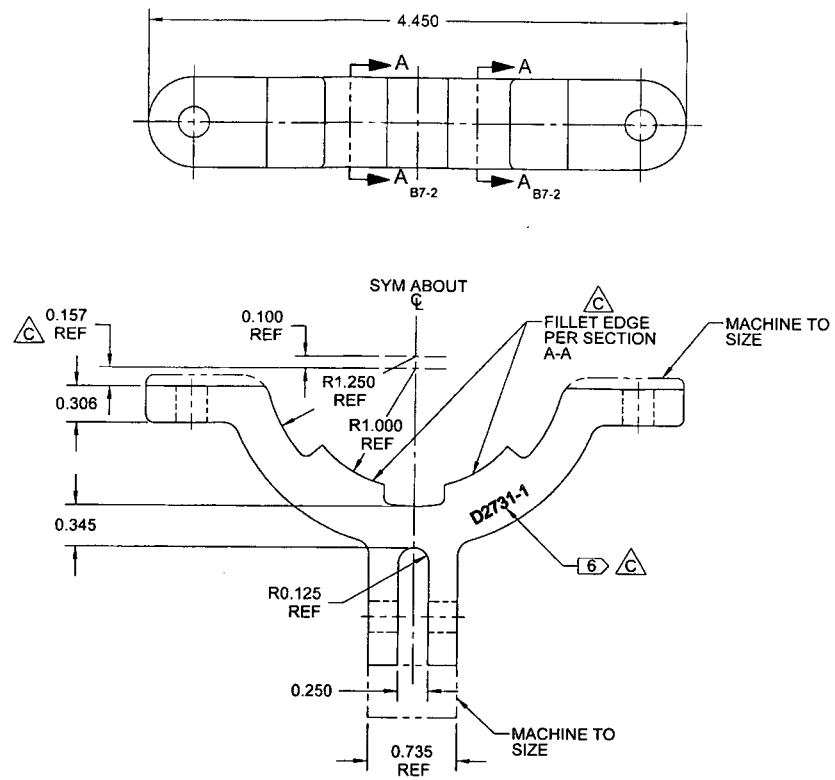
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

  
 SECTION A-A D4-2  
 SCALE 2X  
 R0.06 MIN-R0.10 MAX  
 2 PL



**D2731-1 MOUNTING LUG**

W10 59202

**RELEASED**  
09/05/25/44

DESIGN	KE	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 2 OF 5
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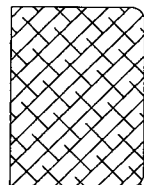
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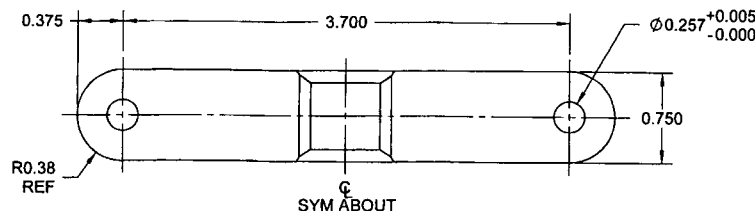
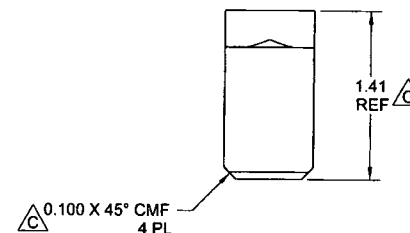
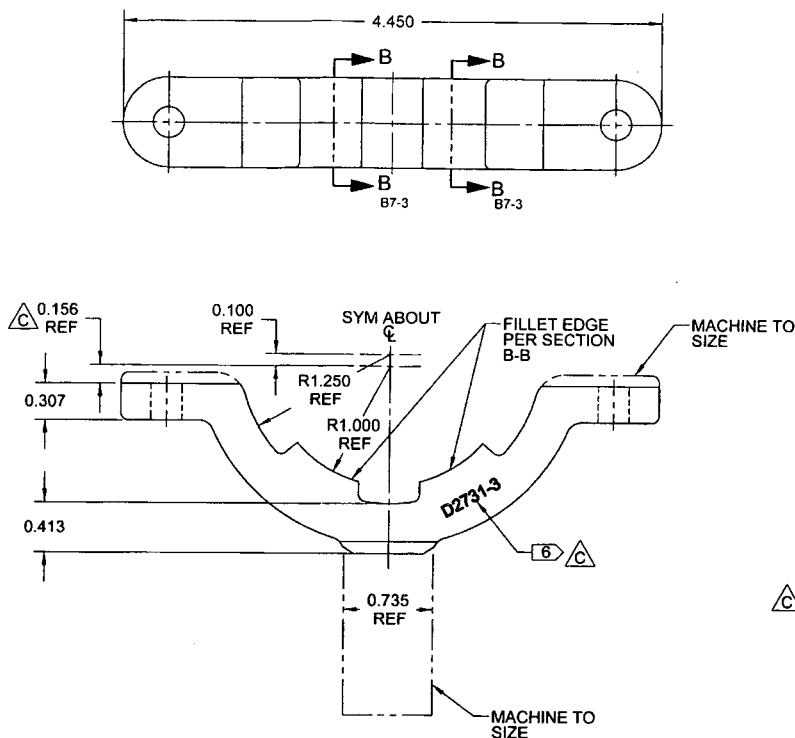
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



R0.06 MIN-R0.10 MAX.  $\triangle C$   
2 PL





$\triangle C$  **SECTION B-B** D4-3  
SCALE 2X



**D2731-3 MOUNTING LUG**

w/0 59202

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09/05/25 M

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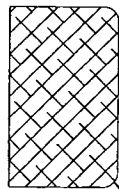
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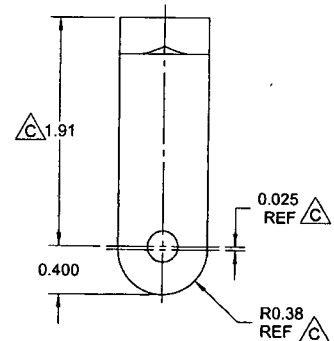
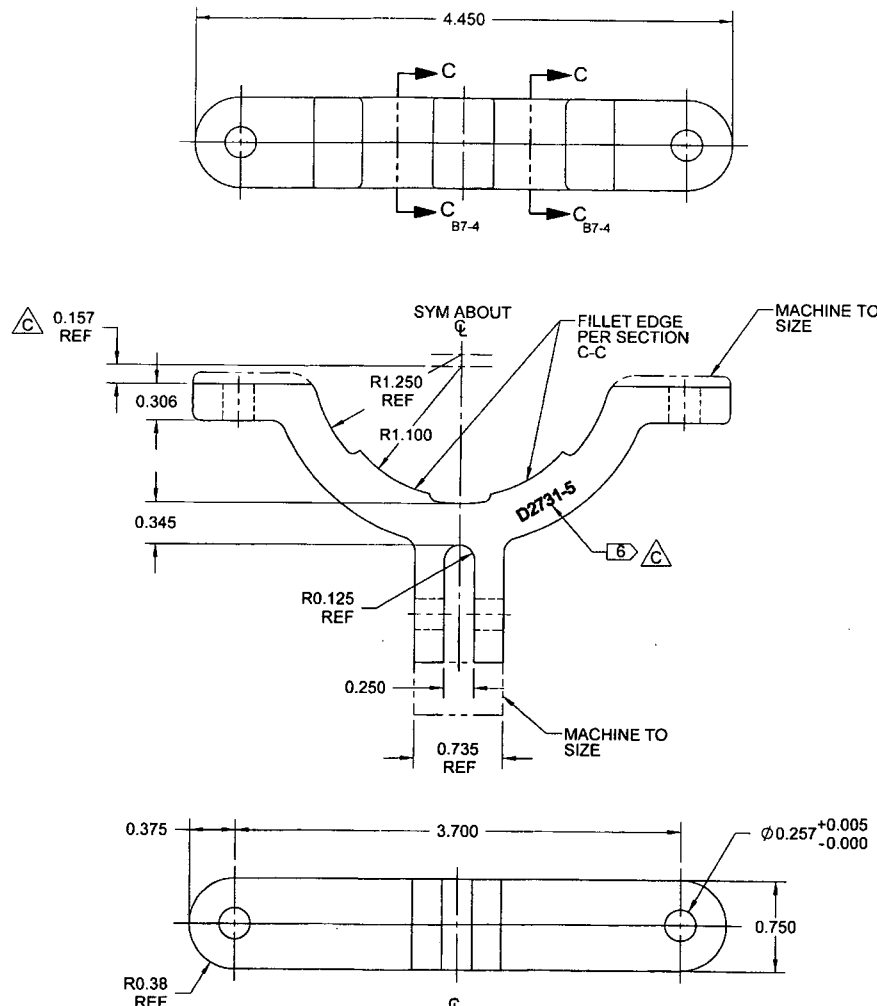
**NOTE:** Date & initial all entries



**SECTION C-C** D4-4  
SCALE 2X



R0.06 MIN-R0.10 MAX  
2 PL



**D2731-5 MOUNTING LUG**

*w/0 59202*

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9/16/25

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MFG. APPR.		D2731	SHEET 4 OF 5
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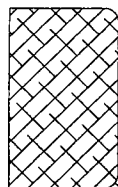
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

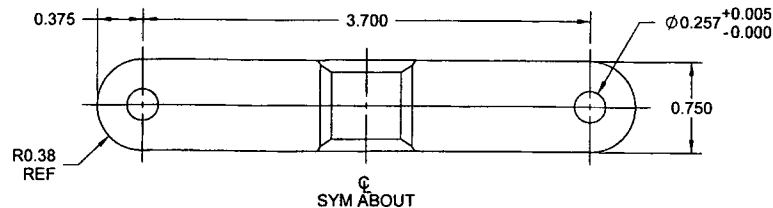
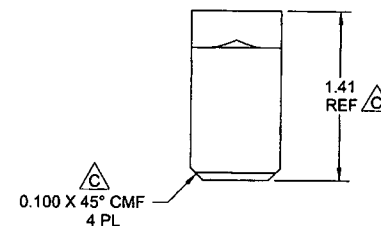
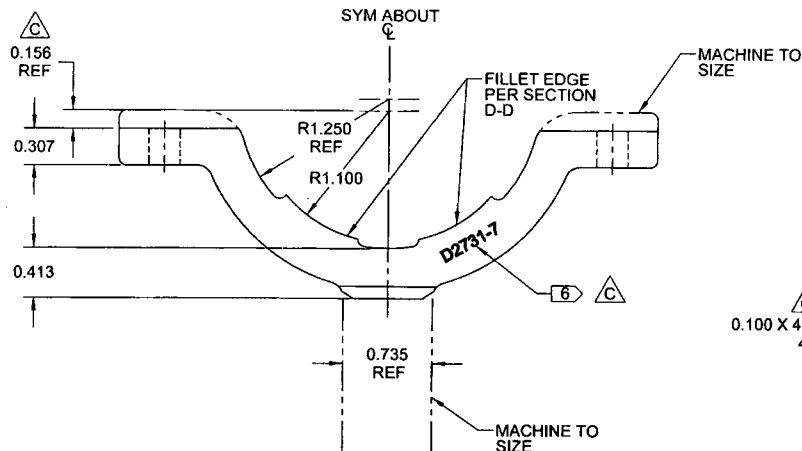
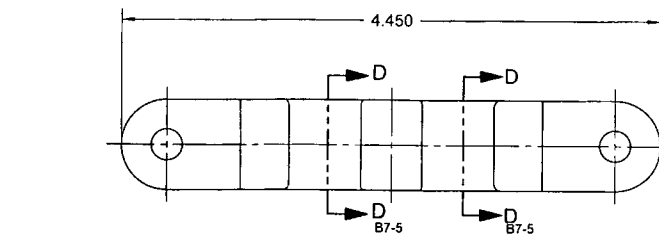
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**SECTION D-D** D4-5  
SCALE 2X



R0.06 MIN-R0.10 MAX  
2 PL



**D2731-7 MOUNTING LUG**

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